

Date: Tuesday, 10/2/2007 10:39:11 AM  
 User: Kim Johnston

## Process Sheet

44

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 212/205 HIGH FED X-TUBE ASSEMBLY
Job Number	: 34930		
Estimate Number	: 10254		
P.O. Number	: N/A	Part Number	: D212664101
This Issue	: 10/2/2007	Drawing Number	: D212-664-141 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: C
Previous Run	: 34929	Material	: N/A
		Due Date	: 10/30/2007
Written By	: JH	Qty:	1 Um: Each
Checked & Approved By	: JH 07.10.02		
Comment	Est Rev:E 04.02.16 Reformat KJ/DS Est Rev:F 06-03-29 Remove Coments on Pick List JLM Est Rev:G 07-04-30 As per Rev C JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-101CHG003

KS 07-10-02

2.0	D6005128	Crosstube material
-----	----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6005-128 Crosstube B26549

Check OD = 2.750"; ID = 2.000"

J.F. 07/10/06

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA113

2-Turn first side as per Folio FA113

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141.

J.F. 07/10/07

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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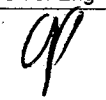
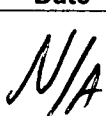

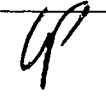

Comment: INSPECT ALL DIM TO DIM SHEET

J.F. 07/10/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.10.17	12	One height is too big 27.1"	 07.10.17 per QSI 642	Tube acceptable. Only 0.650" above tolerance. Other side on high end (26.97) So not too uneven	 N/A EL 7.10.16	 07-10-29	 07.10.17 per QSI 642	 07-10-29

NOTE: Date & initial all entries

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Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA113

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141.

J.F. 07/10/07

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F. 07/10/07

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SC 07-10-07

①

8.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Remove sand and plugs

2-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-141

J.F. 07/10/07

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

JH 7-10-10

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 07/10/10

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JH 7-10-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 34930

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

BENDING

BENDING MACHINE



P70 on 1st page

Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio FT015

EL 7-10-16

13.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

Q 07.10.17 (1)

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549

SR/EL 7-10-17

2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141

J10 7-10-18

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of bending and drilling

J10 7-10-18

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Q 07/10/18

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: 4852

LPI as per ASTM 1417 Level 2

Attach copy of NDT results to work order

C207110119 (1)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order.

C27/10/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 10/2/2007 10:39:12 AM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 34930

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage &amp; ensure results are as per Dwg D212-664-141

07-10-19

20.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

RT 07-10-20

RT 07-10-20

21.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

07-10-22

(1)

22.0

D28931

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2893-1

Support

32779

RT 07-10-22

23.0

D3595

Rubber Cushion (per sq ft)



Comment: Qty.: 0.0840 sf(s)/Unit Total : 0.0840 sf(s)

Rubber Cushion (per sq ft)

.630" X 4.5" 4PCS

Batch:

33833

RT 07-10-22

24.0

MS2192025

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-25

Clamp

104902

RT 07-10-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 34930

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs

A/R 6398 Magnobond

Batch: 104677

Expiry Date: 08-10-01

03-10-22

2-Install clamps as per Dwg D212-664-141. Torque clamps to 80-100 in lb.

ml 07/10/24

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/10/24

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

28.0

D34281

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PLACARD

Batch: 1226249

50

29.0

AN635A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M104679

50

30.0

AN636A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M105125

50

31.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch: M105125

7/10/25 50

(P10) →

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D212-664-101 PAR #: NA Fault Category: Prod / Packaging NCR: Yes No DQA: 12 Date: 07/10/29  
 QA: N/C Closed: 12 Date: 07.10.29

NCR: <u>34530</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/25	# 31.0	missing two(2) washers AN960SD6/G RC Hammer error	<u>[Signature]</u> 05/10/2	ADD missing washers	<u>[Signature]</u> 07/10/25	<u>[Signature]</u> 07/10/25	<u>[Signature]</u> 05/10/2	<u>[Signature]</u> 07/10/25

NOTE: Date & initial all entries

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## Process Sheet

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Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 34930

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: M104021

7/10/25 SO 1X

33.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

7/10/26 SO 1X

34.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-101

Res e 7/10/26 SO 1X

35.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/10/29 SO 1X

Job Completion



U 7-10-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	34930
<b>Description:</b> Crosstube Assembly (205/212/412 High Fwd)	<b>Part Number:</b>	D212-664-141
<b>Inspection Dwg:</b> D212-664-141 <b>Rev:</b> C		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200"	+/-0.010	2.05"	✓			
	R0.063	+/-0.010	R0.063"	✓			
	2.740	+0.005/-0.000	2.743"	✓			
	5.097	+/-0.030	5.109"	✓			
	2.304	+0.005/-0.000	2.308"	✓			
	2.340	+0.005/-0.000	2.345"	✓			
	2.398	+0.005/-0.000	2.403"	✓			
	2.448	+0.005/-0.000	2.453"	✓			
	2.498	+0.005/-0.000	2.502"	✓			
	2.549	+0.005/-0.000	2.554"	✓			
	2.599	+0.005/-0.000	2.603"	✓			
	2.671	+0.005/-0.000	2.675"	✓			
	2.701	+0.005/-0.000	2.707"	✓			
SIDE B	0.200	+/-0.010	2.10"	✓			
	R0.063	+/-0.010	R0.063"	✓			
	2.740	+0.005/-0.000	2.744"	✓			
	5.097	+/-0.030	5.109"	✓			
	2.304	+0.005/-0.000	2.308"	✓			
	2.340	+0.005/-0.000	2.345"	✓			
	2.398	+0.005/-0.000	2.403"	✓			
	2.448	+0.005/-0.000	2.452"	✓			
	2.498	+0.005/-0.000	2.501"	✓			
	2.549	+0.005/-0.000	2.554"	✓			
	2.599	+0.005/-0.000	2.603"	✓			
	2.671	+0.005/-0.000	2.675"	✓			
	2.701	+0.005/-0.000	2.704"	✓			
	126.51	+/-0.020	126.505"	✓			

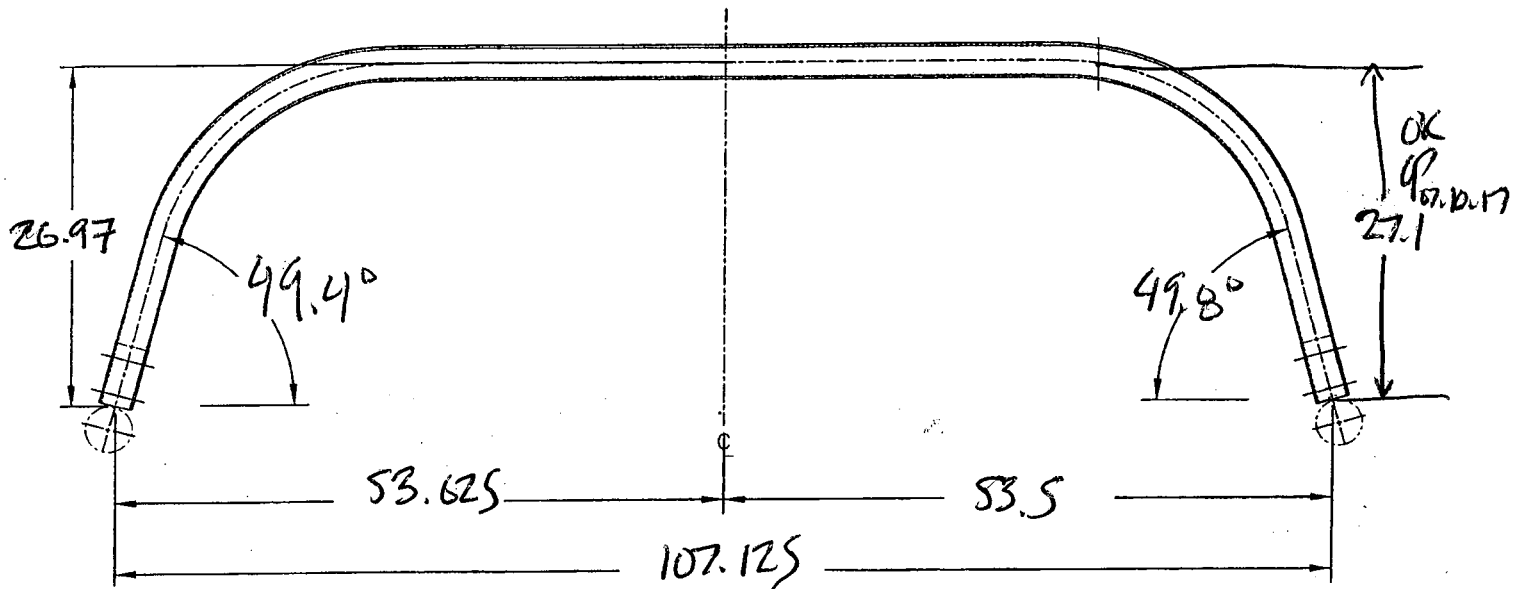
<b>Measured by:</b> J.F.	<b>Audited by:</b> EG	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/10/06	<b>Date:</b> 07.10.07	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-101)	KJ/JLM	
B	06.03.15	Tolerance revised for 5.097 per Dwg Rev update	KJ/JLM	
C	07.05.28	Dwg Rev updated	KJ/JLM	



DART AEROSPACE LTD		Work Order:	34930
Description: Crosstube High Fwd (205/212/412)		Part Number:	D212-664-101
Inspection Dwg: D212-664-141 Rev: C		Page 1 of 1	

Required Dimension	Min	Max
Height	26.79	27.05
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.7



Comments

QC15 Inspection	CP
Date	07.10.17

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.31	Dimensions updated per Dwg Rev C	KJ/JM	

**DART**

DESIGN <b>PH</b>	DRAWN BY <b>PH</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>Q</b>	APPROVED <b>[Signature]</b>	DRAWING NO. D212-664-141	REV. C SHEET 1 OF 3
DATE 07.03.08		TITLE XTUBE ASS'Y (205/212/412 HI FWD) NTS	
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	07.03.08	REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	

**RELEASED**07.04.24 **[Signature]**

Qty	Part Number	Description
X	D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
1	D6005-128	CROSSTUBE
2	D2893-1	SUPPORT
4	D3595-063-450	RUBBER CUSHION
4	MS21920-25	CLAMP (OR MS21920-26)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6005-128  
FINISHED LENGTH =  $126.51 \pm 0.020$
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 10) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT
- 11) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

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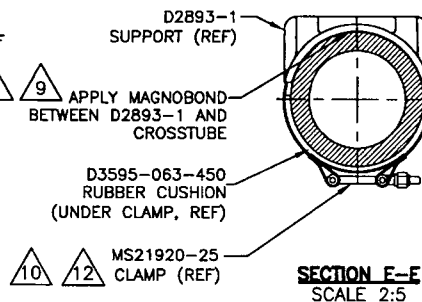
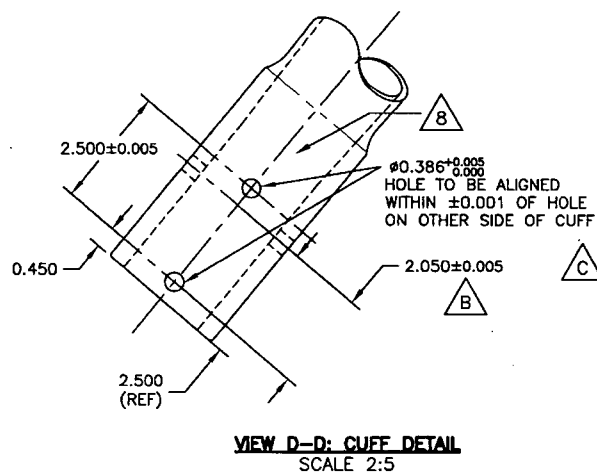
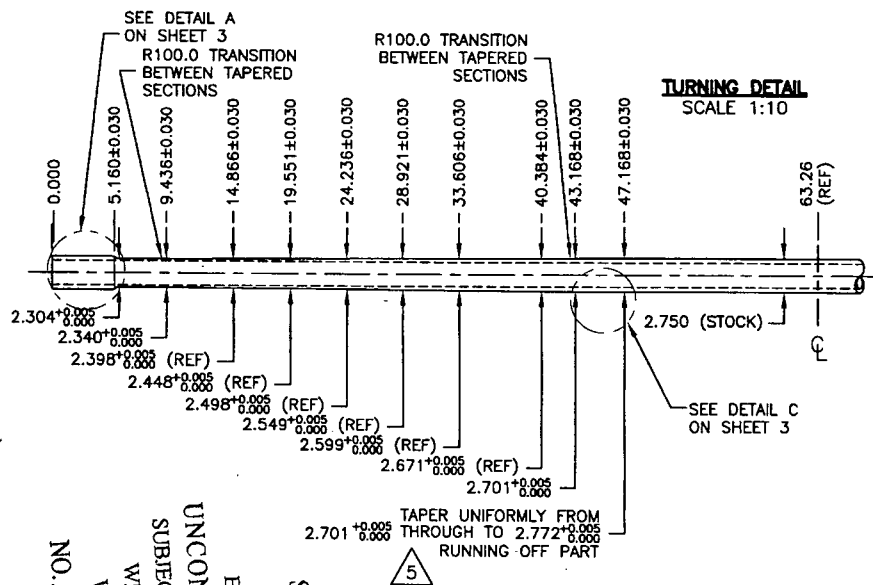
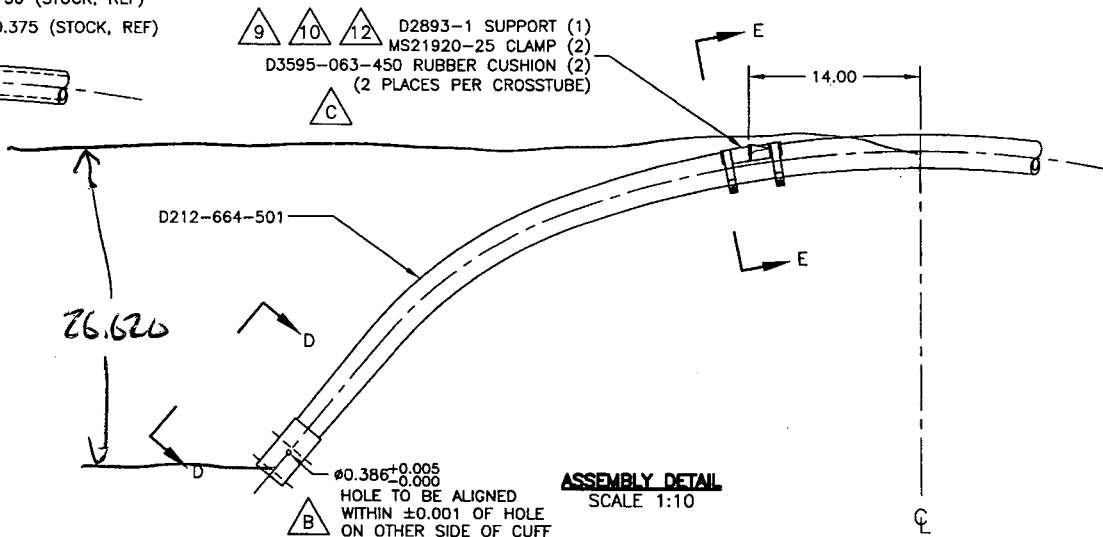
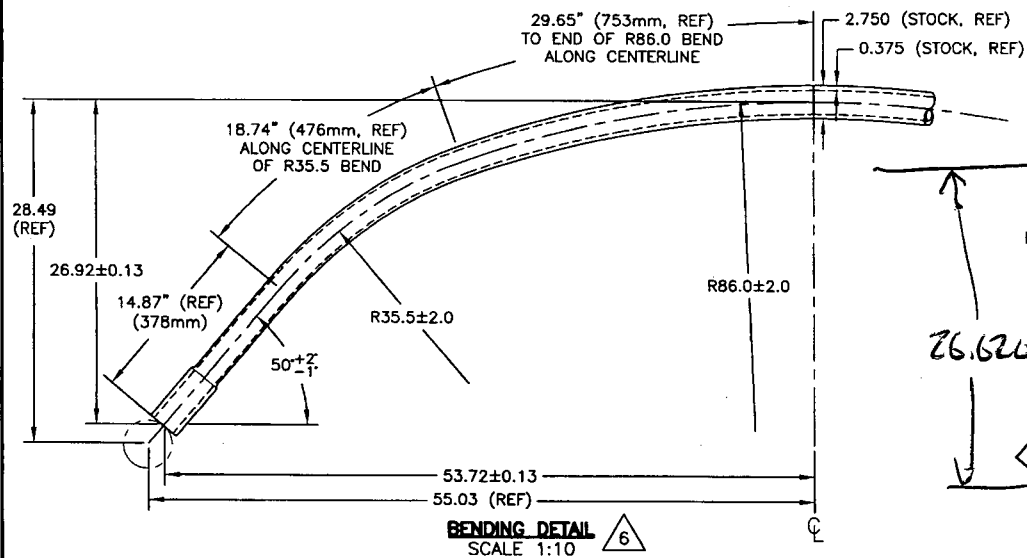
WORK ORDER

NO. 34930

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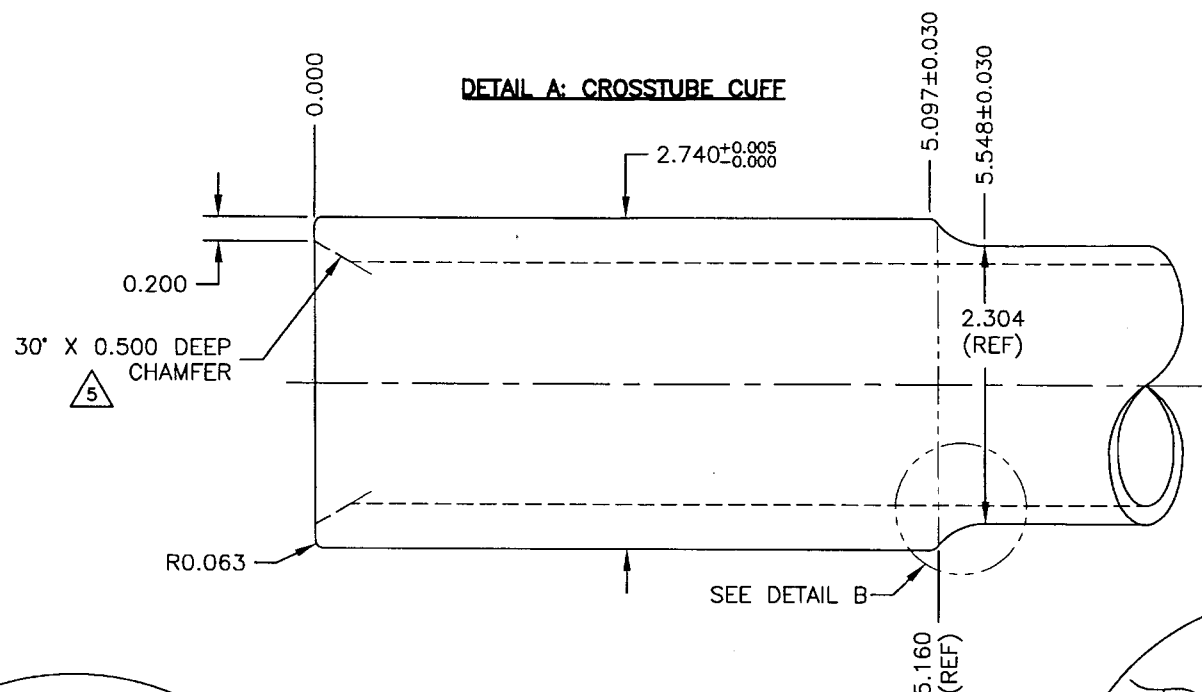
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DESIGN	PH	DRAWN BY	PH	<b>DART</b>	DART AEROSPACE LTD. HAMPSHIRE, ENGLAND, CANADA
CHECKED	9P	APPROVED	4	DRAWING NO.	REV. C
DATE	07.03.08	TITLE	XTUBE ASS'Y (205/212/412 HI FWD)	1:10	SHEET 2 OF 3

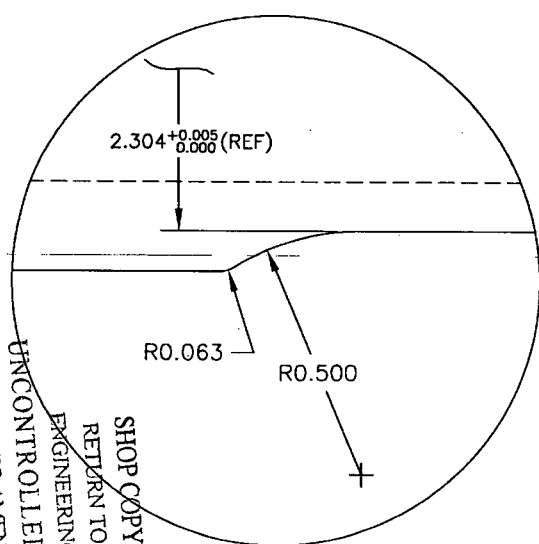
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**RELEASED**  
 67.04.24 (P)  
 PER DUN 827

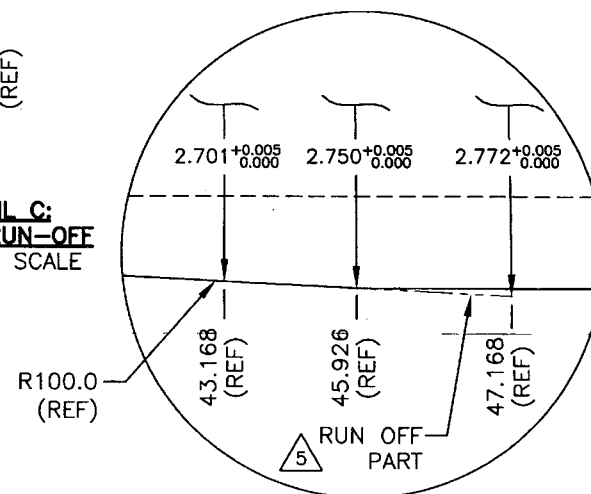
**DETAIL A: CROSSTUBE CUFF**



**DETAIL B: CUFF  
 TRANSITION  
 SCALE 4:1**



**DETAIL C:  
 TAPER RUN-OFF  
 NOT TO SCALE**



NO. 34930  
 WORK ORDER  
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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED J	APPROVED J	DRAWING NO. D212-664-141	REV. C SHEET 3 OF 3
DATE 07.03.08		TITLE XTUBE ASS'Y (205/212/412 HI FWD)		SCALE 1:1	



## LIQUID PENETRANT TEST REPORT

P- 08665

PAGE 1 OF 1

CLIENT Dart Aerospace DATE October 19, 2007 TIME AM ☒ PM ☐  
ATTENTION Bill Beckett ACUREN JOB NO. 187-07-01157  
ADDRESS 1270 Aberdeen Street PO/WO NO. \_\_\_\_\_  
Hawkesbury Ontario K6A 1K7 WORK LOCATION as shown.  
ACCEPTANCE STD. E1417-99 REV./DATE 99

PROJECT Cross Tube Inspection  
ITEM(S) EXAMINED Inspection of X-tube assemblies, 212/205 high Fed, 212/205 High AFT, 206L FWD, 412 High AFT, 212/205 high Fed as listed Below

OB DESCRIPTION \_\_\_\_\_ PROCEDURE NO. LT-0002 REV./DATE E1417-99 TECHNIQUE NO. LT-0002 REV./DATE \_\_\_\_\_  
PART NO. X-Tube assemblies as listed. MATERIAL 7075 Aluminum THICKNESS < 1/2"  
SCOPE 100% examination of all outer surfaces per standard ASTM E1417-99  
Type 1, Method A, Level 2.

## TEST DETAILS

METHOD ☒ FLUORESCENT ☐ VISIBLE ☐ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED  
FAMILY BRAND Magnaflux Batch # 07F046 BLACK LIGHT S/N 8168 ☒ OUTPUT > 1000  $\mu$ W/cm<sup>2</sup> ☒ AMBIENT < 2 fc  
PENETRANT Zygo ZL67 MINIMUM DWELL TIME 10 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE  
PENETRANT REMOVER Water MINIMUM DRY TIME > 10 MIN. OTHER \_\_\_\_\_  
DEVELOPER NA MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N 1093266 CAL DUE DATE 8/9/13  
DEVELOPER TYPE ☐ NON AQUEOUS ☐ AQUEOUS ☐ DRY

## TEST SURFACE

SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL  
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/ 50°F ☒ 10°C/ 50°F TO 52°C/ 125°F ☐ > 52°C/ 125°F

RESULTS- ☐ METRIC ☒ IMPERIAL

ITEM	COMMENTS	ACCEPT	REJECT
P.N. <u>D212664100</u> x 1 piece			
<u>Job # 34929</u>			
P.N. <u>D212664201</u> x 1 piece			
<u>Job # 30420</u>			
P.N. <u>D206667103</u> x 2 pieces			
<u>Job #'s 34926 and 34139</u>			
P.N. <u>D412664203</u> x 1 piece			
<u>Job #33537</u>			
P.N. <u>D212664101</u> x 2 pieces			
<u>Job #'s 34931 and 34930</u>			
<u>All Seven (7) Units Acceptable.</u>			

Scope of Services  
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Standard of Care  
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

## SIGNATURES

CLIENT REPRESENTATIVE Matthew Murdoch SIGNATURE Matthew Murdoch DTR # 187-07-01157  
TECHNICIAN (SIGNATURE): Mark Westover  
NAME (PRINT): Mark Westover 1<sup>ST</sup> TECHNICIAN 2<sup>ND</sup> TECHNICIAN  
CGSB LEVEL 2 SNT LEVEL 2 CGSB LEVEL \_\_\_\_\_ SNT LEVEL \_\_\_\_\_  
CGSB REG. NO. 53213 CGSB REG. NO. \_\_\_\_\_  
REPORT REVIEWED BY: \_\_\_\_\_ NAME \_\_\_\_\_ INITIALS \_\_\_\_\_